

Date: Monday, 25/09/2006 11:02:51 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BEARPAW	
Job Number	: 28715				
Estimate Number	: 11647				
P.O. Number	: N/A		Part Number	: D2995	
This Issue	: 25/09/2006 S.O. No. : N/A		Drawing Number	: D2995 REV A1	
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: N/A		Drawing Revision	: A1	
Previous Run	: N/A		Material	: N/A	
Written By			Due Date	: 02/10/2006	
Checked & Approved By			Qty:	6 Um: Each	
Comment	: Est A 01.03.07 New Issue EC				
Additional Product					
Job Number: 					
Seq. #:	Machine Or Operation:	Description :			
1.0	MUHMWB10	UHMW 1" Black 			
Comment: Qty.: 2.7777 sf(s)/Unit Total: 16.6662 sf(s) Pick: M1005C01 +1 Material: Black UHMW 1" Batch 102169 J.F. 06/09/25					
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 			
Comment: HAAS CNC VERTICAL MACHINING #1 Cut blank: 19.50" x 20.00" Inspect material for defects or damage prior to machining Machine as per folio FA119 Deburr J.F. 06/09/25					
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE J.F. 06/09/25					
4.0	QC8	SECOND CHECK 			
Comment: SECOND CHECK J.L 06/09/27					
5.0	PACKAGING 1	PACKAGING RESOURCE #1 			
Comment: PACKAGING RESOURCE #1 Identify and Stock 0500573-13 Location: 104/9/27 (6)					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/09/28
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/09/28	# 2.0	one part has a small medium mark in the left lower pocket	CP 06.09.27 PV QSI 042	Replace Scrap Part	CP 06/09/28	J 06-09-27	IP 06.09.27 PV QSI 042	J 06-09-28

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW

Job Number: 28715

Part Number: D2995

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

206/09/28

Job Completion



U 06/09/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

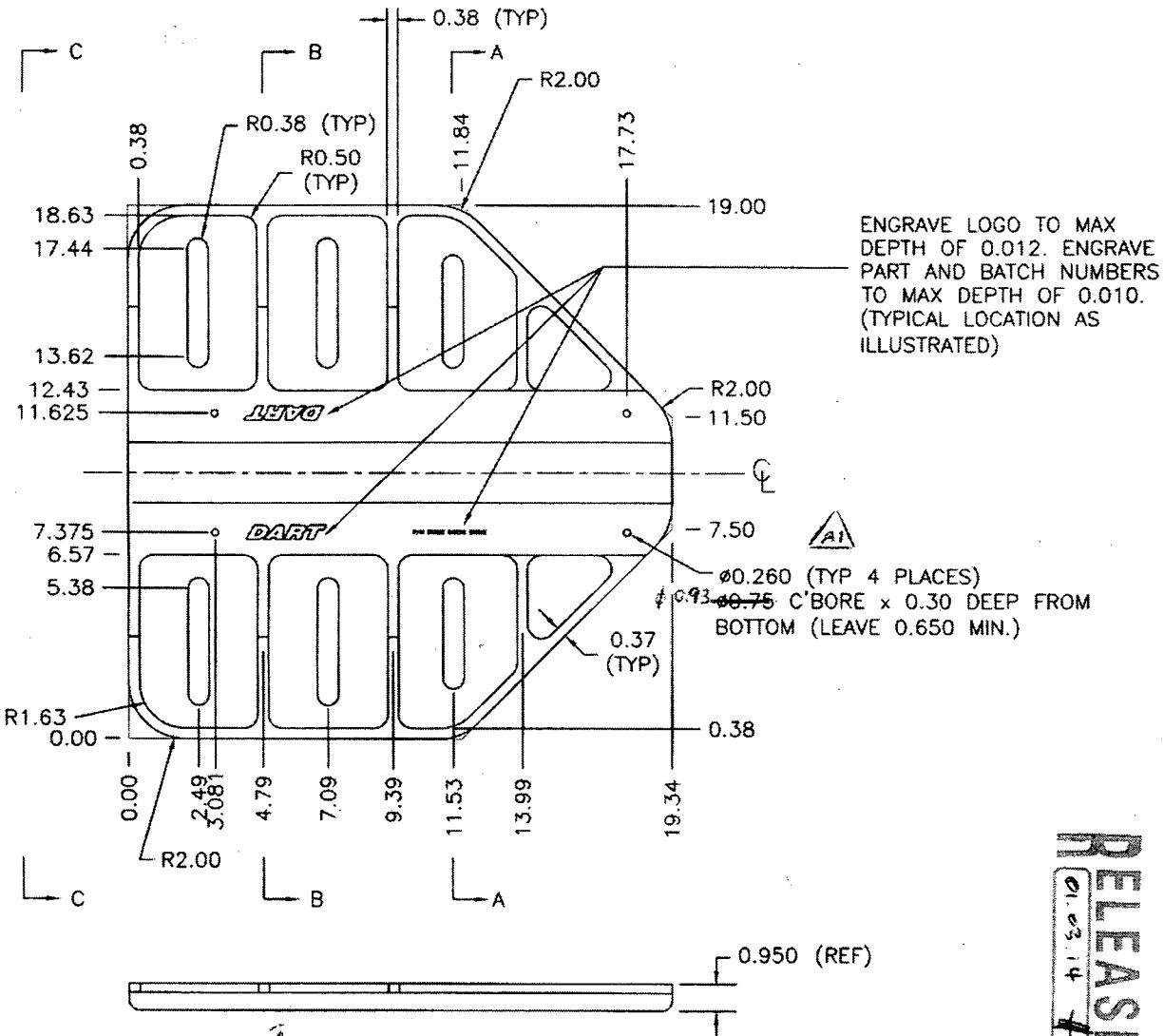
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
ISSUED	APPROVED	DRAWING NO. D2995
CHEKED	APPROVED	REV. A
DATE	DATE	SHEET 1 OF 2
01.02.23	01.02.23	1:6
A	A	SCALE
41	41	BEARPAW
RP	RP	TITLE
03.01.06	03.01.06	NEW ISSUE
Ø 0.93	Ø 0.93	Ø 0.93 Ø 0.75

RELEASED
(01.03.14)**REFERENCE ONLY**

BEARPAW IS SYMMETRIC ABOUT CENTERLINE (EXCEPT FOR ENGRAVING)
MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689

1.00 THICK (MACHINE TO 0.950)

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

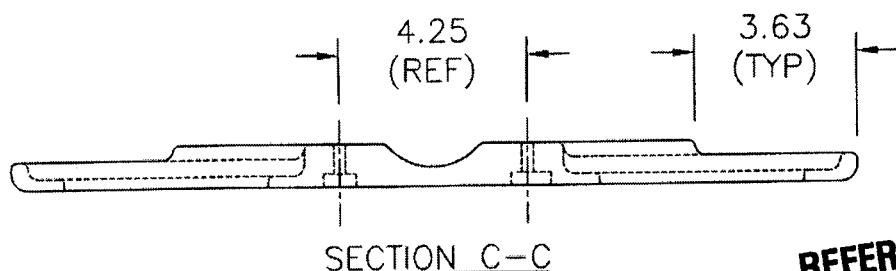
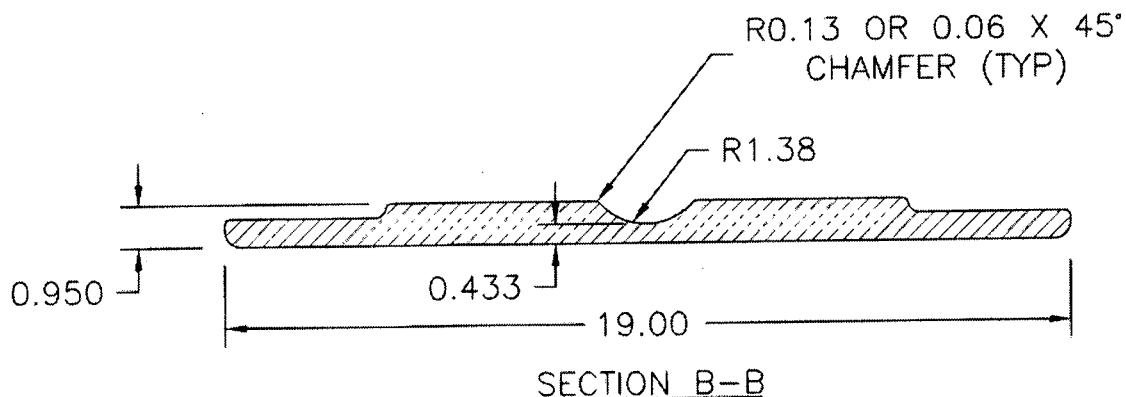
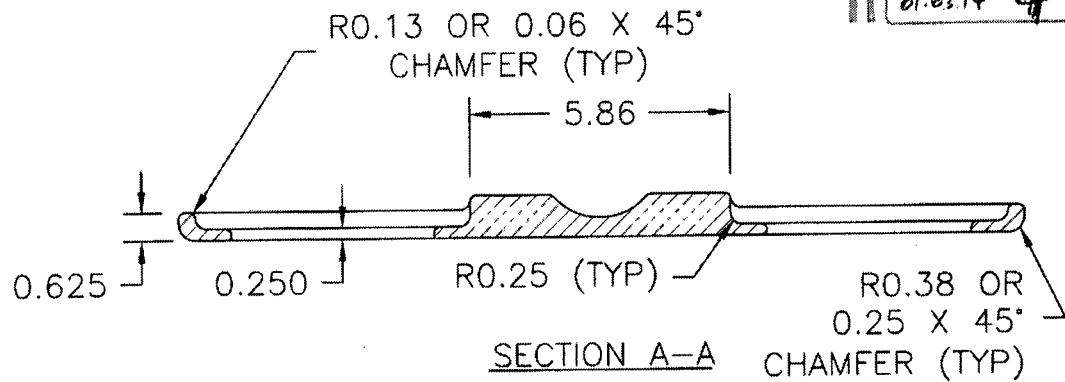
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>A</i>	APPROVED <i>A</i>	DRAWING NO. D2995	REV. A SHEET 2 OF 2
DATE 01.02.23		TITLE BEARPAW	SCALE 1:4

RELEASED
01.03.14 *A***REFERENCE ONLY****Copyright © 2001 by DART AEROSPACE LTD**

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	28715
Description: Bear Paw	Part Number:	D2-95
Inspection Dwg: D2-95 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

x First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.625	± 0.010	0.630	—		vern	
0.250	$\pm .11$	0.247	—		"	
0.025	± 0.030	0.25	—		R-Q	
0.25x45°	"	0.267x45°	—		vern	
5.86	± 0.030	5.859	—		"	
0.950	± 0.010	0.948	—		"	
0.433	"	0.438	—		"	
19.00	± 0.020	19.00	✓		TAPEMEASUR	
4.25	"	4.248	✓		vern	
3.63	"	3.632	—		"	
7.375	± 0.010	7.381	—		"	
11.625	$\pm .11$	11.625	—		"	
0.38	± 0.030	0.372	—		"	
3.081	± 0.010	3.085	—		"	
17.73	± 0.030	17.75	✓		TAPEMEASUR	
19.34	"	19.34	✓		"	
9.0.260	$\frac{+.005}{-.001}$	0.260	✓		vern	
0.30	± 0.010	0.308	✓		vern depth mic.	
9.0.93	± 0.020	0.93	✓		vern	

Measured by:	EJ	Audited by:	SPW	Prototype Approval:	N/A
Date:	06/09/26	Date:	06/09/26	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	